

Work Order ID 73225

Friday, August 26, 2011 10:27:03 AM



Page 1

Item ID: D3315-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/08/26 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3315

Rev B

100

0.00



FLOW WATERJET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-

Deburr if necessary

1010 .063

B11-8-30

(7)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-30

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 1108/30

(47)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

N/A

[Signature]

Small Fab

Memo

0.00

Small Fab

Deburr if necessary

140

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1- Form using DT8751 Die as per Dwg D3315Rev: B 2- Form using
DT8179 Die and form joggle using DT8157 as per Dwg D3315Rev: B

[Signature] 8/26/09/01
[Signature] 8/26/09/02 (7)

150

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

8/26/09/06

[Signature]

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 73225

Friday, August 26, 2011 10:27:03 AM



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Item ID: D3315-1

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Large Fab	Large Fab	0.00							
	Memo	0.00							
	Weld hard surface using D3315-1T3 as per QSI 004 and Dwg D3315 Rev:								
	<input type="checkbox"/> Qty Part Number Description Batch <input type="checkbox"/> A/R								
	N/A 7560 Hardcoat Rod								
170 QC	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00							
	Quality Control								
180 QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

X7 11-09-08 JRL

Sutorlos

(X7)
7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73225

Friday, August 26, 2011 10:27:03 AM



Page 4

Item ID:	D3315-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearplate					
Start Date:	8/26/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	9/9/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
<div style="display: flex; justify-content: space-between;"> <div> <p><i>M 117338</i></p> <p>3200C</p> </div> <div> <p>Memo</p> <p>START TIME: <i>8:50</i></p> <p>FINISH TIME: <i>9:20</i></p> </div> <div> <p>0.00</p> <p>OVEN TEMPERATURE:</p> </div> </div>									
200 QC Quality Control	QC3- Inspect Part Finish	0.00							
<div style="display: flex; justify-content: space-between;"> <div></div> <div> <p>Memo</p> <p>Identify on inside surface using a permanent fine point marker with the following: <input type="checkbox"/>TCCA-PDA, Dart Aerospace Ltd. <input type="checkbox"/>P/N: D3315-1, B/N: BXXXXXX <input type="checkbox"/>For Product Eligibility see PDA04-17 <input type="checkbox"/>and Stock <input type="checkbox"/>Location: <i>ST 496</i></p> </div> <div> <p>0.00</p> </div> </div>									
210 Packaging Packaging	Packaging	0.00							
<div style="display: flex; justify-content: space-between;"> <div></div> <div> <p>Memo</p> </div> <div> <p>0.00</p> </div> </div>									

TX Ø M-2 11/09/14

*measured
counted 1000*

7 Ø 11/09/14

7x SP 11-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73225

Page 5

Friday, August 26, 2011 10:27:03 AM

Item ID: D3315-1

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Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/15

ME
11-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 10:27:01 AM

Page 1

Work Order ID: 73225

Parent Item: D3315-1

Parent Item Name: Wearplate



Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: A 05.05.12 New issue KJ/JLM
 IPP Rev:B As per Rev B 06-03-24 JLM
 IPP Rev:C now water jet 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S16GA

Purchased

No

100

sf

134.3000

1.695

7.0625

12



HB11-8-30

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

134.3

116791

32.5

117500

101.8

117500

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	73225
Description: Wearplate		Part Number:	D3315-1
Inspection Dwg: D3315	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

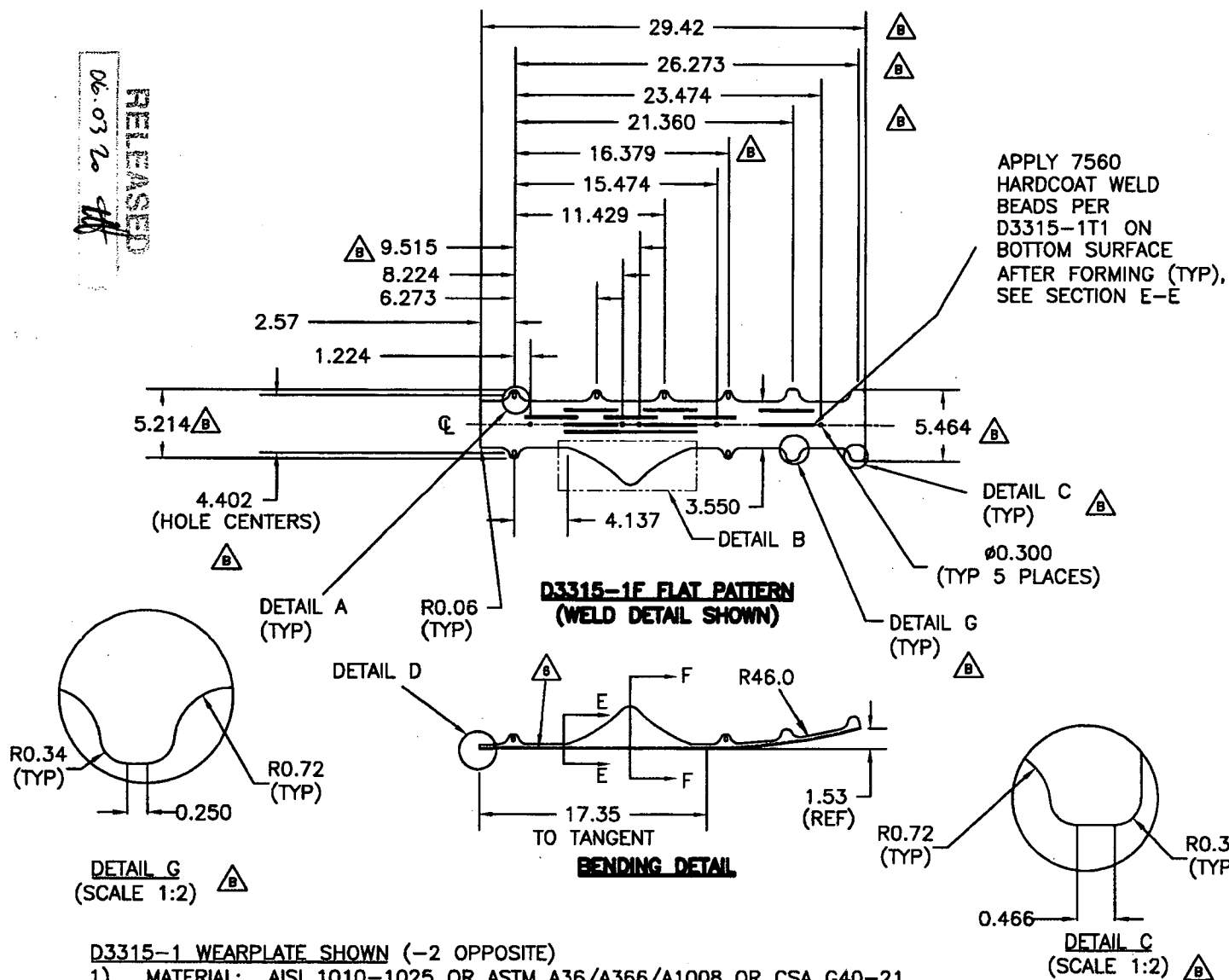
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266 x 0.450	+0.006/-0.001 x +/-0.010	0.266 x 0.453	x		✓ RB02	
4.402	+/-0.010	4.400	x		✓	
4.137	+/-0.010	4.137	x		✓	
3.550	+/-0.010	3.555	x		✓	
5.464	+/-0.010	5.468	x		✓	
5.214	+/-0.010	5.214	x		✓	
1.224	+/-0.010	1.226	>		✓	
2.57	+/-0.030	2.579	x		✓	
6.273	+/-0.010	6.270	x		✓	
8.224	+/-0.010	8.227	x		PROW302	
9.515	+/-0.010	9.519	x		P	
11.429	+/-0.010	11.426	x		P	
15.474	+/-0.010	15.474	x		T RB01	
16.379	+/-0.010	16.379	x		T	
21.360	+/-0.010	21.360	x		T	
23.474	+/-0.010	23.474	x		T	
26.273	+/-0.010	26.273	>		T	
29.42	+/-0.030	29.42	x		T	
0.060	+/-0.010	0.063	x		✓	
Ø0.300	+0.006/-0.001	0.302	x		✓	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 17-8-30	Date: 11/08/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.28	New Issue	KJ	MA

DESIGN	8/4	DRAWN BY	8/4	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
				D3315	SHEET 1 OF 4
DATE				TITLE	SCALE
06.01.31				WEARPLATE	1:12
A				NEW ISSUE	
B				UPDATE DIMENSIONS	



- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED

"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
NOTICE

SUBJECT TO THE
WITHOUT NOTICE
WORK ORDER
NO. 73225

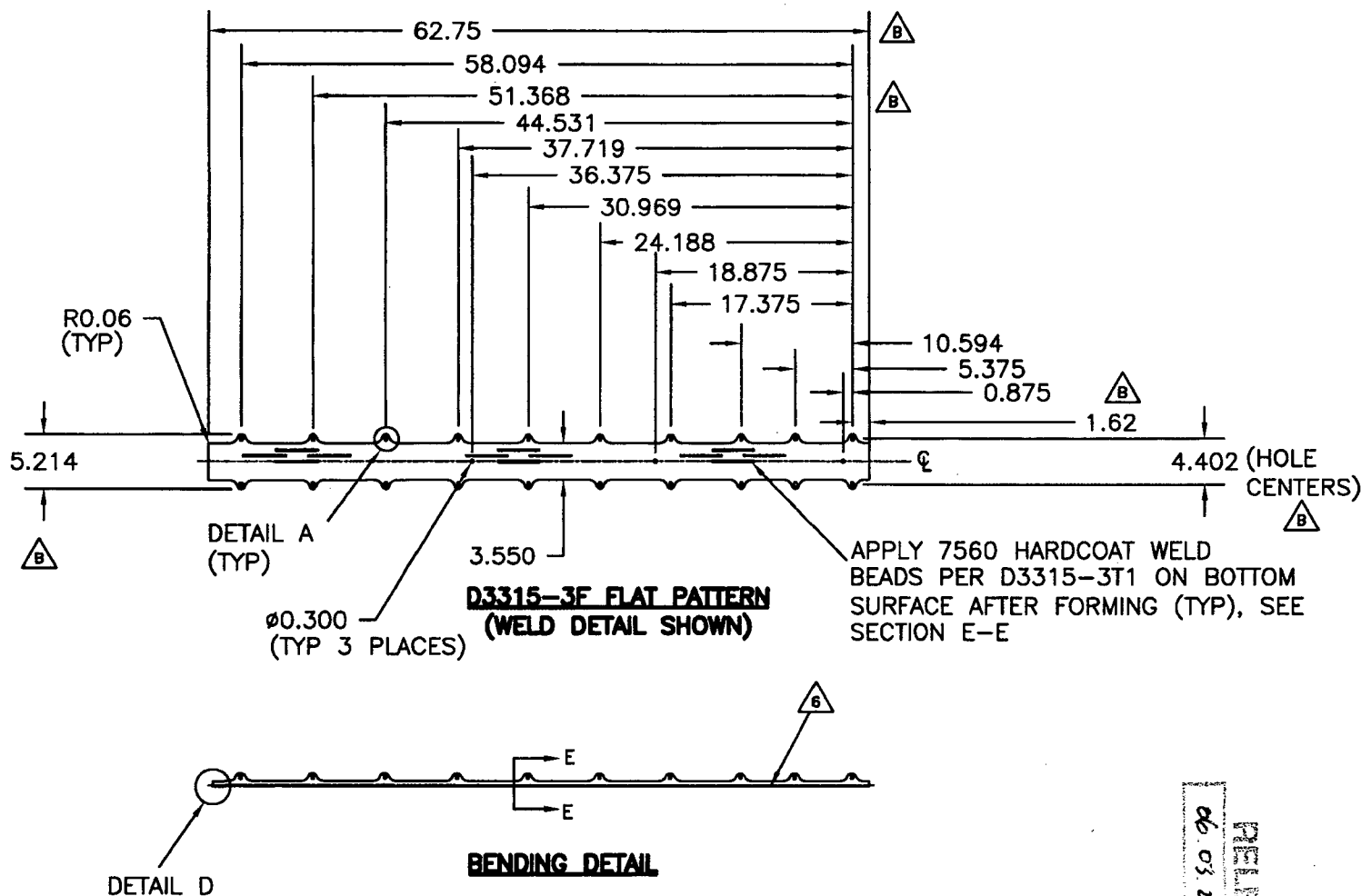
CZ1103126

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RELEASED
06-03-20

DART

D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

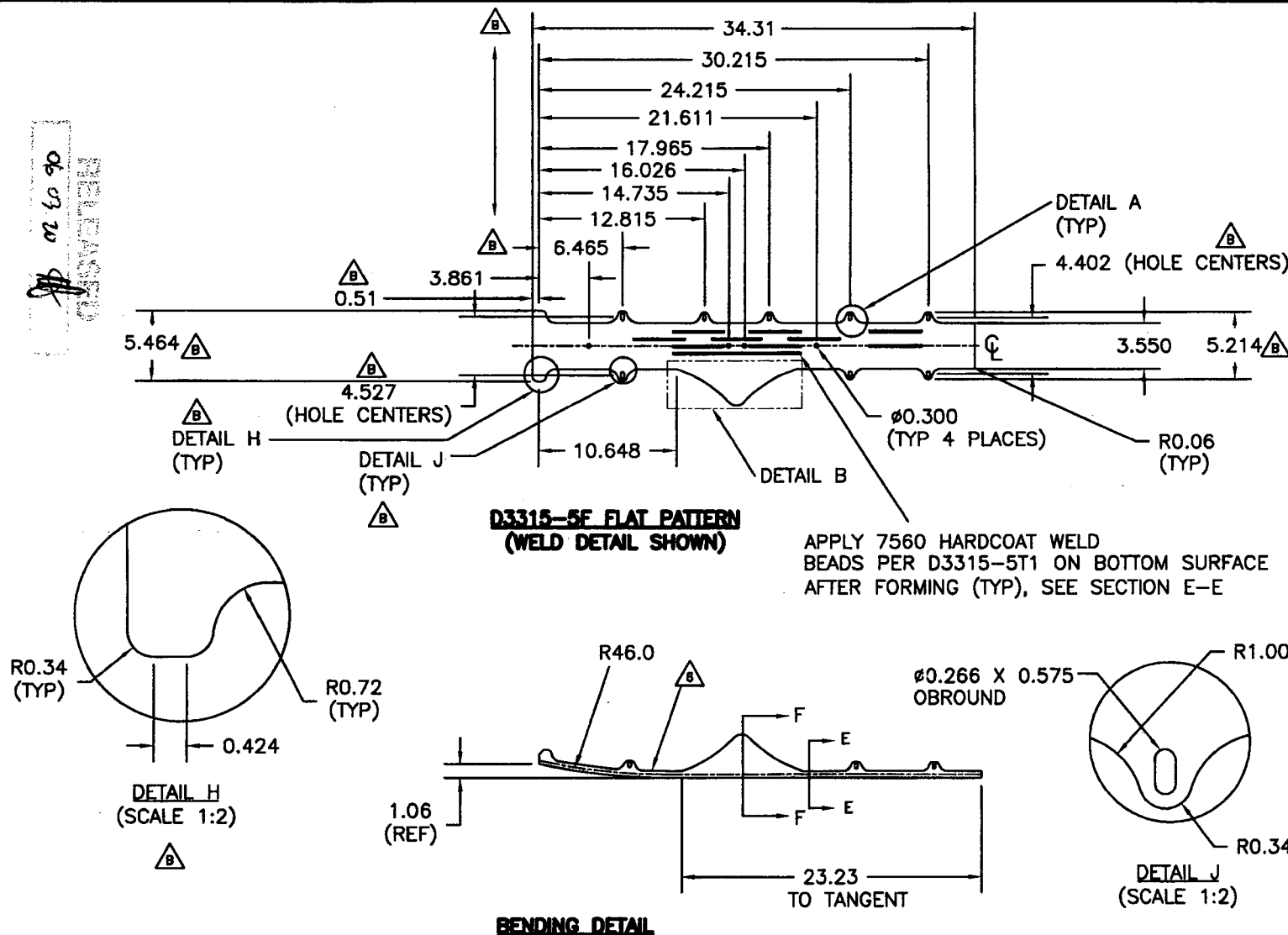
RELEASED
26 03 20

DESIGN	DRAWN BY	TITLE	REV. B
PH	PH	D3315	SHEET 2 OF 4
CHECKED	APPROVED	WEARPLATE	SCALE
DATE			1:16
06.01.31			

DART AEROSPACE LTD
HAMKESBURY, ONTARIO, CANADA

DART

DESIGN	84	DRAWN BY	84	DART AEROSPACE LTD
CHECKED		APPROVED		HAMKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
		TITLE	WEARPLATE	SHEET 3 OF 4
				SCALE 1:12



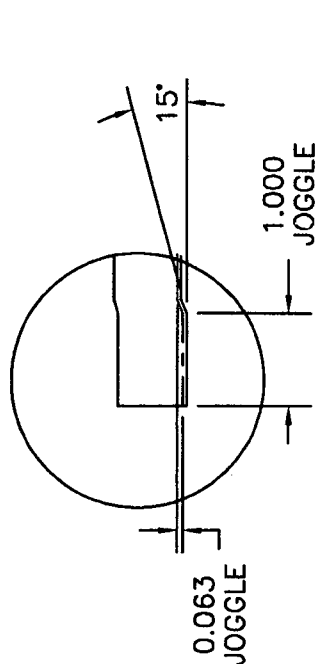
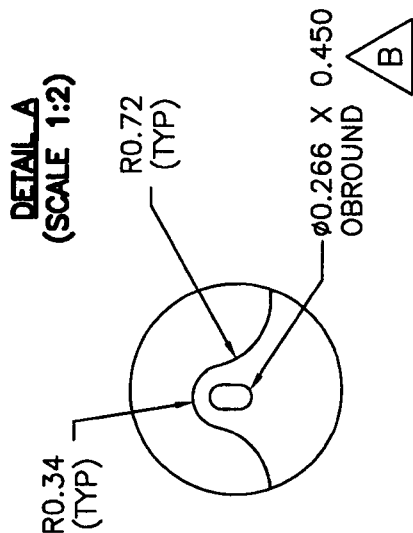
D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

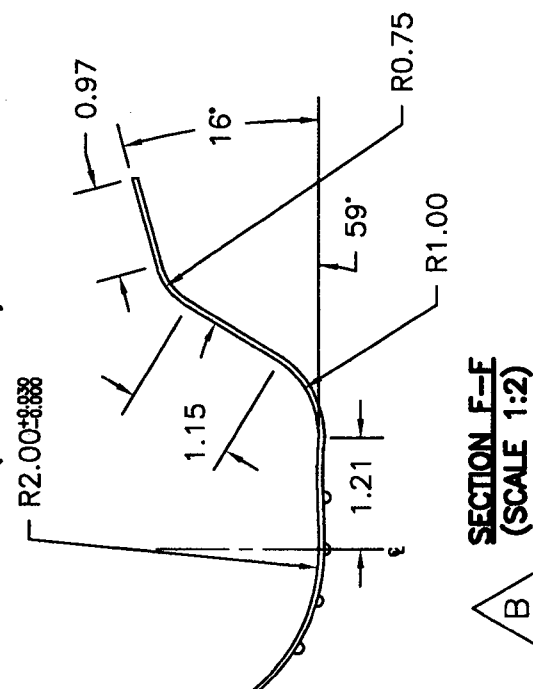
06.03.20



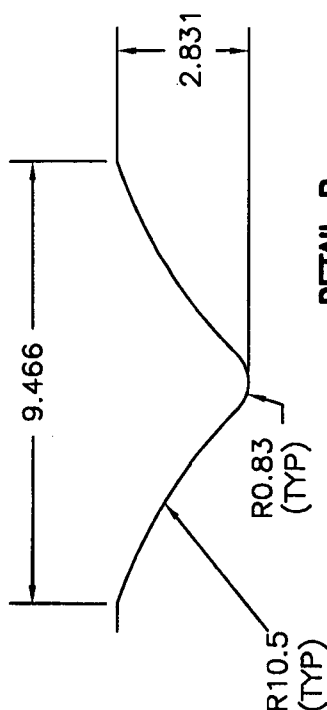
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31		TITLE WEARPLATE	SCALE NTS



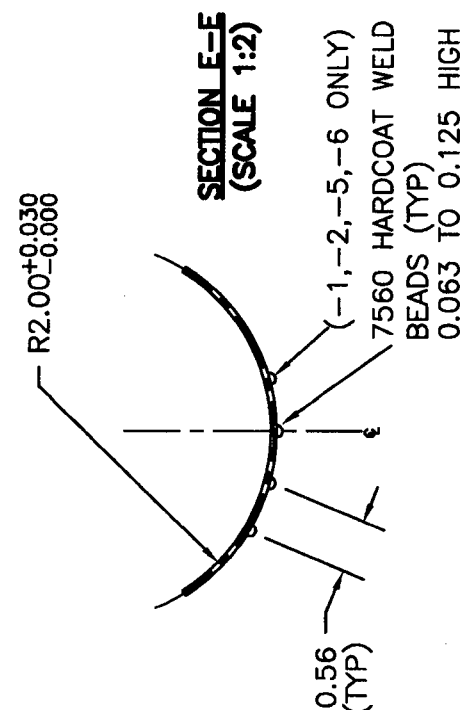
DETAIL D
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)



DETAIL B
(SCALE 1:4)



SECTION E-E
(SCALE 1:2)

RELEASED
06.03.20

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